

Work Order ID 132413

132413

Page 1

Item ID: D2364

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Deck Plate Fwd

Stop

NS2

Start Date: 5/07/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2364

Rev F

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2364 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

2024.063

(6)

DC 15/05/17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(6)

DC 15/05/17

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(6)

MAY 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

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May-07-15 2:41:03 PM

Page 2

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 Revision ID: Stop ***NS2***
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 Required Date: 5/07/15 Req'd Qty: 6.00 ***6*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				6x			15/05/15
Small Fab	Memo 1- counter sink holes as per dwg D23642- deburr if necessary	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				6			DAS 38 9-89
Quality Control	Memo	0.00							MAY 20 2015
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				6	0		15/05/21
Hand Finishing	Memo	0.00							

DQA: _____ Date: _____



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Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐															
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐															
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 122480</i> Memo START TIME: <i>10:05</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>10:35</i>	0.00 0.00				<i>6</i>	<i>0</i>	<i>15-6-1</i>	<i>0303</i>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(6)</i>			<i>DAS</i> <i>38</i> <i>9-89</i> <i>JUN 02 2015</i>
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST225</i> Memo	0.00 0.00				<i>6x</i>			<i>DAS</i> <i>28</i> <i>9-89</i> <i>JUN 02 2015</i>

DQA: _____ Date: _____



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Work Order ID 132413***132413***

Page 4

Item ID: D2364

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Deck Plate Fwd

Stop ***NS2***

Start Date: 5/07/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ML5 JUN 03 2015

ML5 JUN 03 2015

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Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER :																																																																					

Picklist Print

May-07-15 2:41:02 PM

Page 1

Work Order ID: 132413

132413

Parent Item: D2364

D2364

Parent Item Name: Deck Plate Fwd

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	190.6680	0.6469	4.085684			

M2024T3S 063

2024-T3 .063 sheet

05/05/17

Location

Loc Qty

Loc Code

MAT022

190.668

m127866

16

m130525

174.668

4.9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	1324/13
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

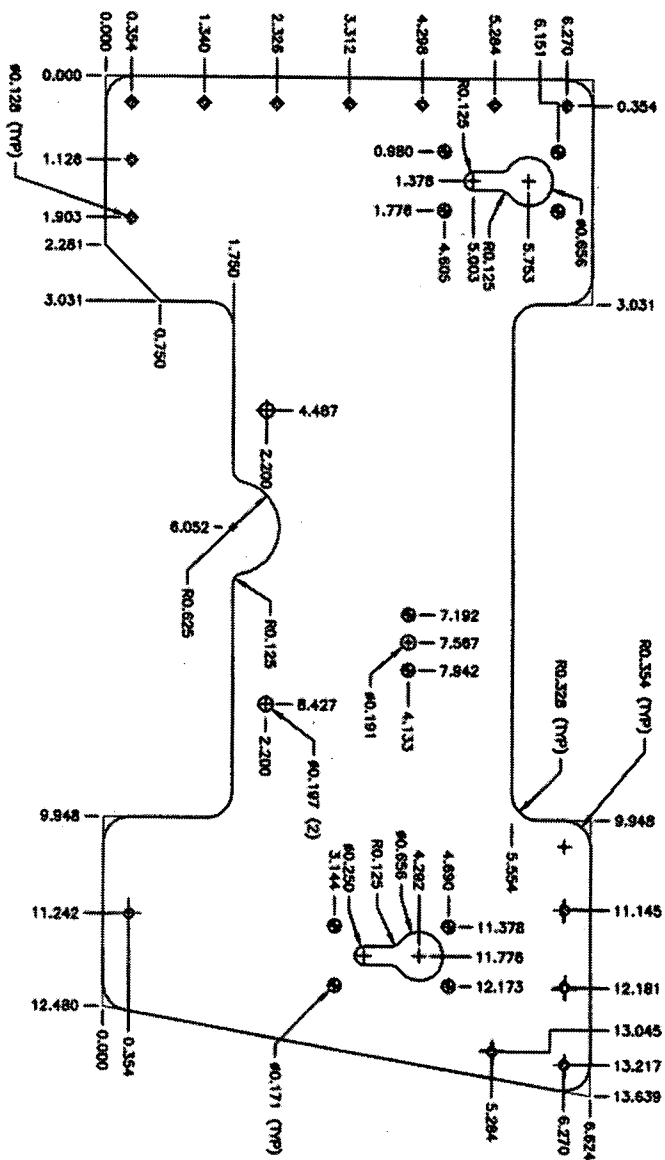
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.625	/		V-Dc-02	
Ø0.171	+0.005/-0.000	Ø.171	/		V-Dc-01	
0.354	+/-0.010	.355	/		Tape	
11.242	+/-0.010	11.240	/			
3.031	+/-0.010	3.033	/			
1.903	+/-0.010	1.901	/			
1.128	+/-0.010	1.130	/			
0.354	+/-0.010	.355	/			
1.340	+/-0.005	1.342	/			
2.326	+/-0.010	2.325	/			
3.312	+/-0.010	3.315	/			
4.298	+/-0.010	4.299	/			
5.284	+/-0.010	5.285	/			
6.151	+/-0.010	6.153	/			
6.270	+/-0.010	6.272	/			
0.354	+/-0.010	.353	/			
3.031	+/-0.010	3.030	/			
Ø0.656	+0.005/-0.000	.655	/			
5.003	+/-0.010	5.001	/			
4.605	+/-0.010	4.607	/			
1.776	+/-0.010	1.778	/			
0.980	+/-0.010	.983	/			
4.487	+/-0.010	4.487	/			
7.192	+/-0.010	7.191	/			
7.567	+/-0.010	7.569	/			
7.942	+/-0.010	7.944	/			
Ø0.191	+0.005/-0.000	Ø.190	/			
Ø0.197	+0.005/-0.000	Ø.196	/			
11.145	+/-0.010	11.145	/			
12.181	+/-0.010	12.183	/			
11.378	+/-0.010	11.375	/			
11.776	+/-0.010	11.775	/			
12.173	+/-0.010	12.174	/			
4.690	+/-0.010	4.692	/			
0.250	+0.005/-0.000	.249	/			
3.141	+/-0.010	3.143	/			
0.171	+0.005/-0.000	.170	/			

Measured by:	DC	Audited by:	38 9-89	Prototype Approval:	N/A
Date:	15/05/17	Date:	MAY 19 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

COUNTER SINK HOLES:
 ◆ C'SINK Ø0.225 x 100° (UPDATED FROM 4 TO 14 HOLES BY 05.11.2011 TO CORRECT CAD ERROR)
 ◆ C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CHECKED	APPROVED	DRAWING NO.	REV. F	SHEET 1 OF 1	DATE
DRAWN BY			D2364			98.06.19
DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA			LITTER DECK PLATE, 350			
TITLE			SCALE			
NEW ISSUE			MOVED KEYWAY			
95.01.14			0.191 WAS 0.197			
95.02.09			GEOMETRY CHANGES			
98.06.19			0.063-0.071 THICK WAS 0.071 (TSR A371)			

98/06/22 KE



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